

Work Order ID 53213

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October 27, 2009 8:01:19 AM

Item ID: D2221-1

Accept



Setup Start



Revision ID: H

Stop



Item Name: Rib

Start Date: 27/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 09/10/27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

100 Large Fab 0.00



Large Fab

Large Fab

Memo

0.00

(12)

Large Fab

1- Cut as per dwg D2221-2- Deburr and remove identification markings on tube

SAD 09-10-28

110 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

→ Soskobes

(12)

Quality Control

120 Identify as per dwg & Stock Location: W/A 0.00



Packaging

Memo

0.00

SAD

(12)

Packaging

09-10-28

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Page 2

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SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							



QC

Quality Control

Memo

0.00

09/10/29 JJ

MF 09-10-28

Picklist Print

Page 1

October 27, 2009 8:01:28 AM

Work Order ID: 53213



Parent Item: D2221-1RevH



Parent Item Name: Rib

Start Date: 27/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304TS0.750W.065



304 SQ Tube .75x.75x.065W

Purchased

No

100

f

460.8319

101.0526



SAD 09-10-28

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

WA

460.8318947

112398

460.831895

101.0526

END Bar Scrap 0.3 sq(ft) x 12 = 3.6 sq (ft)

B# 112398 ↗

8

7

6

5

4

3

2

1

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASER
08/11/11/10

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 53213

PL 27-10-09

A NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 42.00 lbs APPROX
 8) MASK ALL HOLES PRIOR TO POWDER COATING

H

REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); REVISED SECTION F (ZN B8-4); ADDED OWN DIM FOR D2221-1 ON SHEET 5 (SHEET 5) TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.

MB 08.09.18

G

MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR .06.00 DIM WAS +/-0.01 AND .56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT

AJS 08.06.16

F

ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET

PH 05.06.07

E

CHANGE HINGE

CP 01.04.19

D

CHANGE LATCH

BW 96.06.21

C

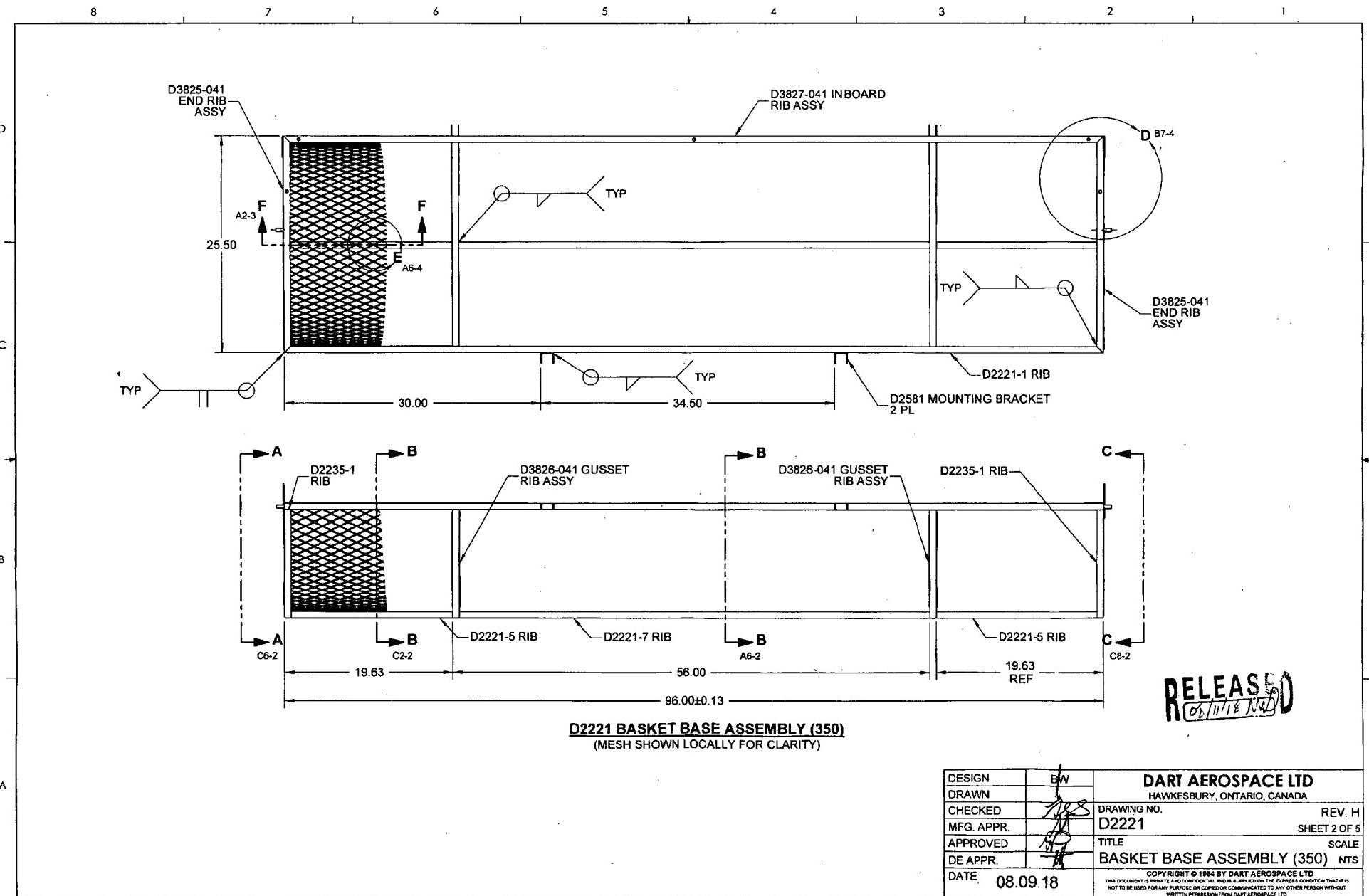
SEPARATE BASKET AND LID

KH 95.11.21

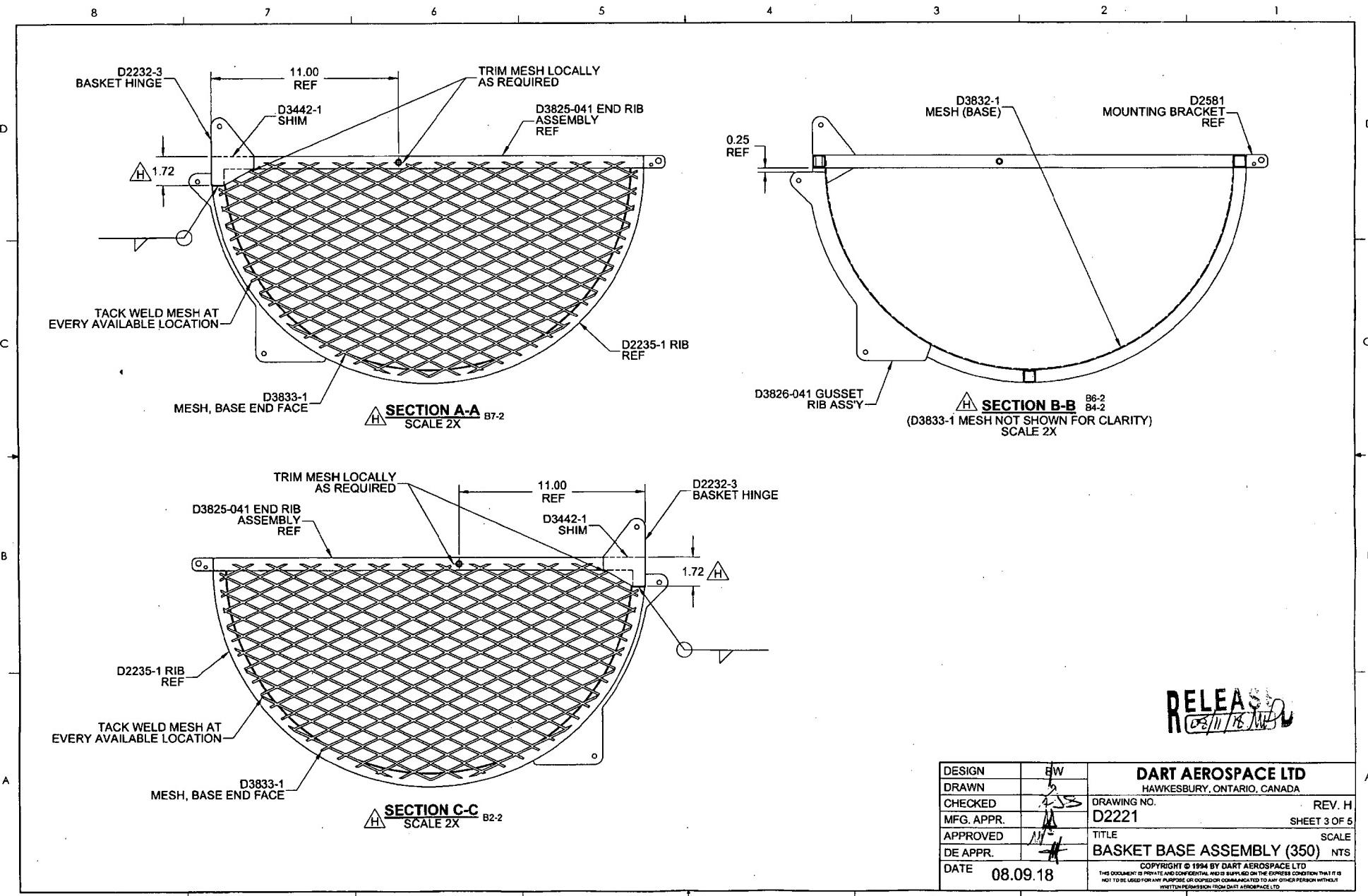
REV. DESCRIPTION BY DATE

DESIGN	BW	DART AEROSPACE LTD		
DRAWN	<i>b</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>PL</i>	DRAWING NO.	REV. H	
MFG. APPR.	<i>PL</i>	D2221	SHEET 1 OF 5	
APPROVED	<i>PL</i>	TITLE	SCALE	
DE APPR.	<i>PL</i>	BASKET BASE ASSEMBLY (350) NTS		
DATE	08.09.18	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS EXCLUDED FROM THE EXPORT CONTROL ACT. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

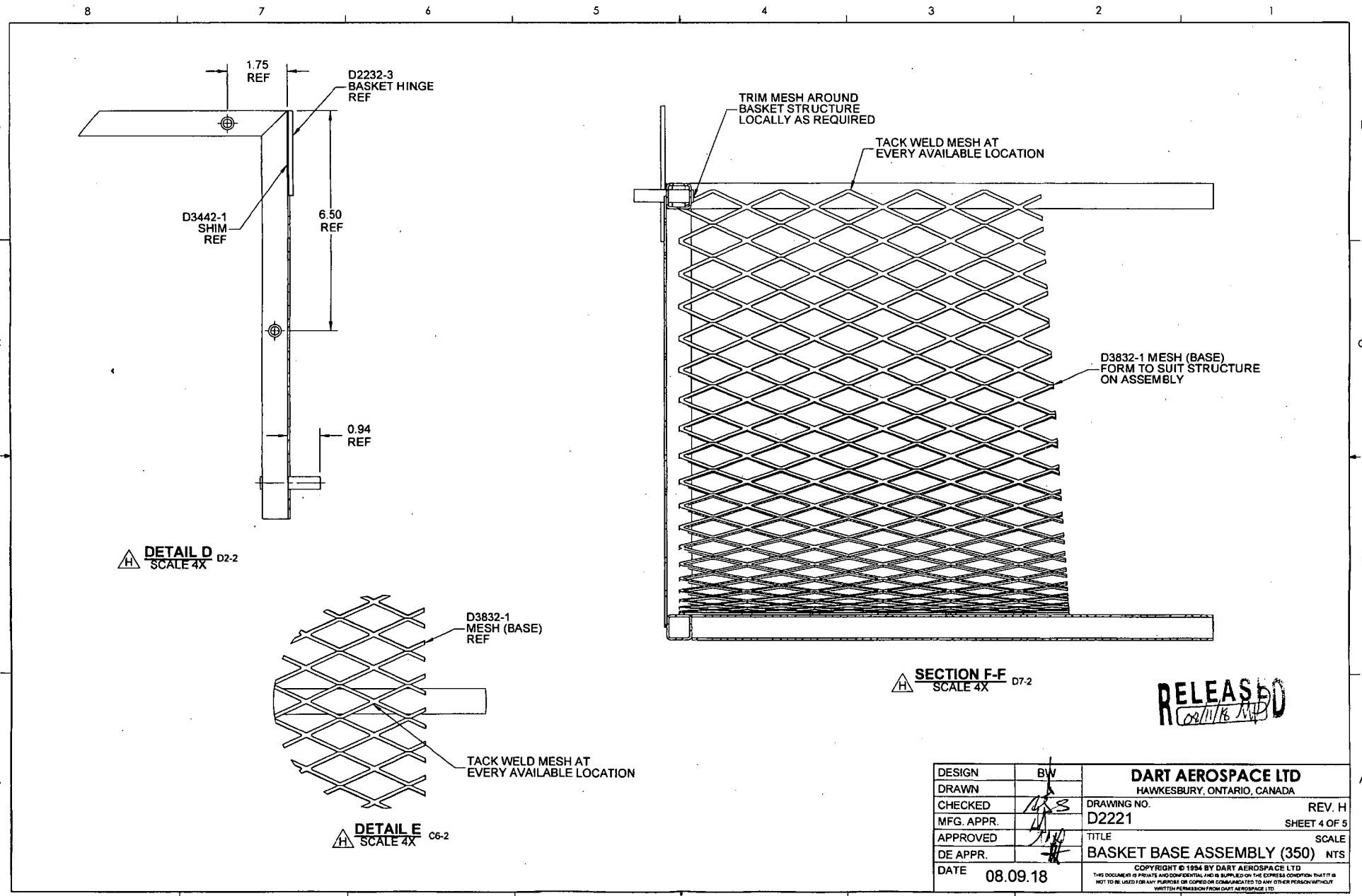
w/o 53213



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w/o 53213



DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKSLEY, ONTARIO, CANADA	
CHECKED	MJS	DRAWING NO.	REV. H
MFG. APPR.	MM	D2221	SHEET 4 OF 5
APPROVED	TJW	TITLE	SCALE
DE APPR.	#	BASKET BASE ASSEMBLY (350) NTS	
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w/o 53213

